

Work Order ID 82761

82761

Page 1

April-09-12 8:49:40 AM

Item ID: D3891-3

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Gasket

Stop

NS2

Start Date: 4/09/12

Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/10/12

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3891

A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3891

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4111 Neo. } C.125
EPDM } Blend.
SER } foam.

(4)

WH/Sm-
12-4-10

(4)

WH/Sm-
12-4-11

Work Order ID 82761***82761***

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April-09-12 8:49:40 AM

Item ID: D3891-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket

Start Date: 4/09/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/10/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Sizlaw/11

(4)

Quality Control

130

Identify as per dwg & Stock Location: 22A

0.00

130

Packaging

Memo

0.00

Packaging

12/4/11 (4)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/4/12

MK
12-4-11

Picklist Print

April-09-12 8:49:39 AM

Page 1

Work Order ID: 82761

Parent Item: D3891-3

Parent Item Name: Gasket

Start Date: 4/09/12

Required Date: 4/10/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 09.02.04 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4111NS.125		Purchased	No			100	sf	400.0800	3.704	15.595789			

4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"

Location

Loc Qty

Loc Code

MAT052

400.08

114937

400.08

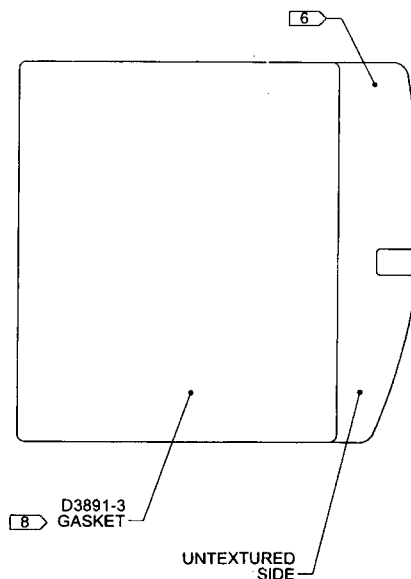
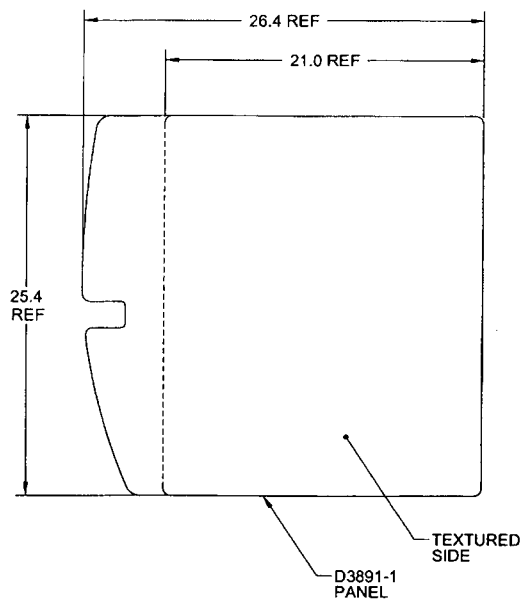
114937

(4)

Jm-
12-4-11

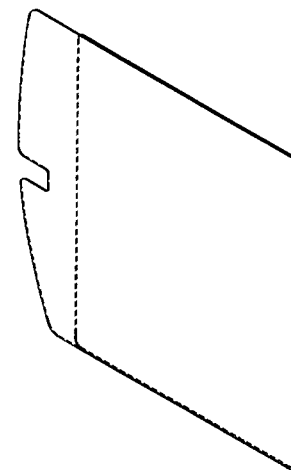
PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-041	PANEL, FWD LH
2	1	D3891-1	PANEL
3	1	D3891-3	GASKET
4	A/R	3M 1300	ADHESIVE

**D3891-041 PANEL, FWD LH**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 3.67 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.



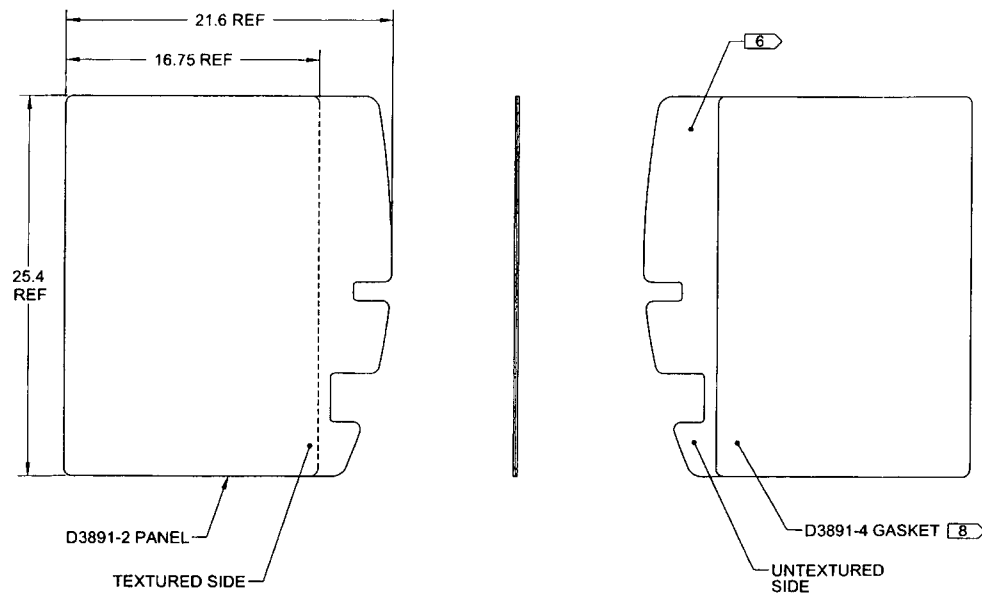
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82761

RELEASED
C9/26/16

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.01		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWING NO. D3891		SHEET 1 OF 6	
TITLE PANEL, FWD		SCALE NTS	
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PARTS LIST

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D3891-042	PANEL, FWD RH
2	1	D3891-2	PANEL
3	1	D3891-4	GASKET
4	A/R	3M 1300	ADHESIVE

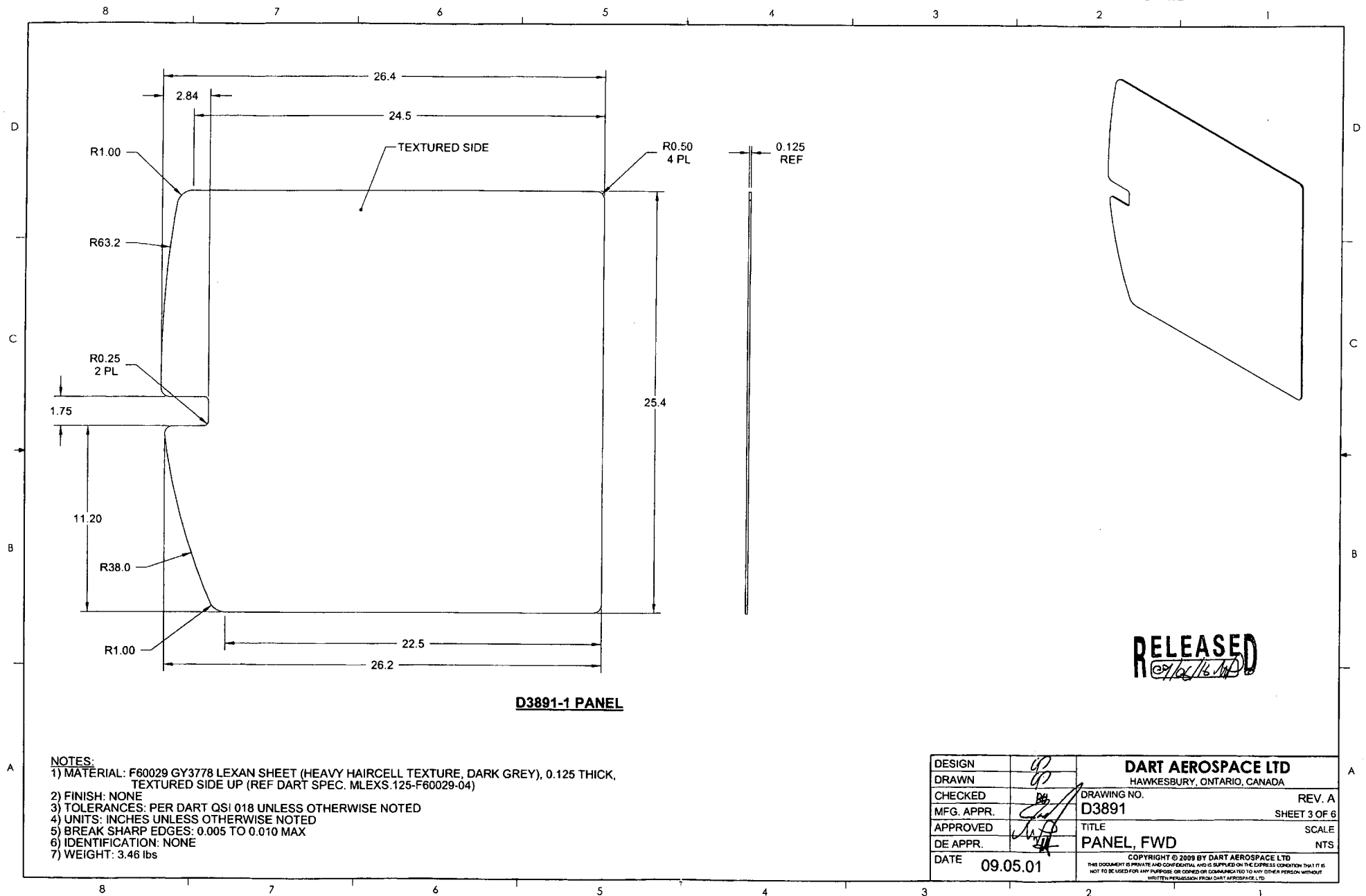
**D3891-042 PANEL, FWD RH**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-042" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.93 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

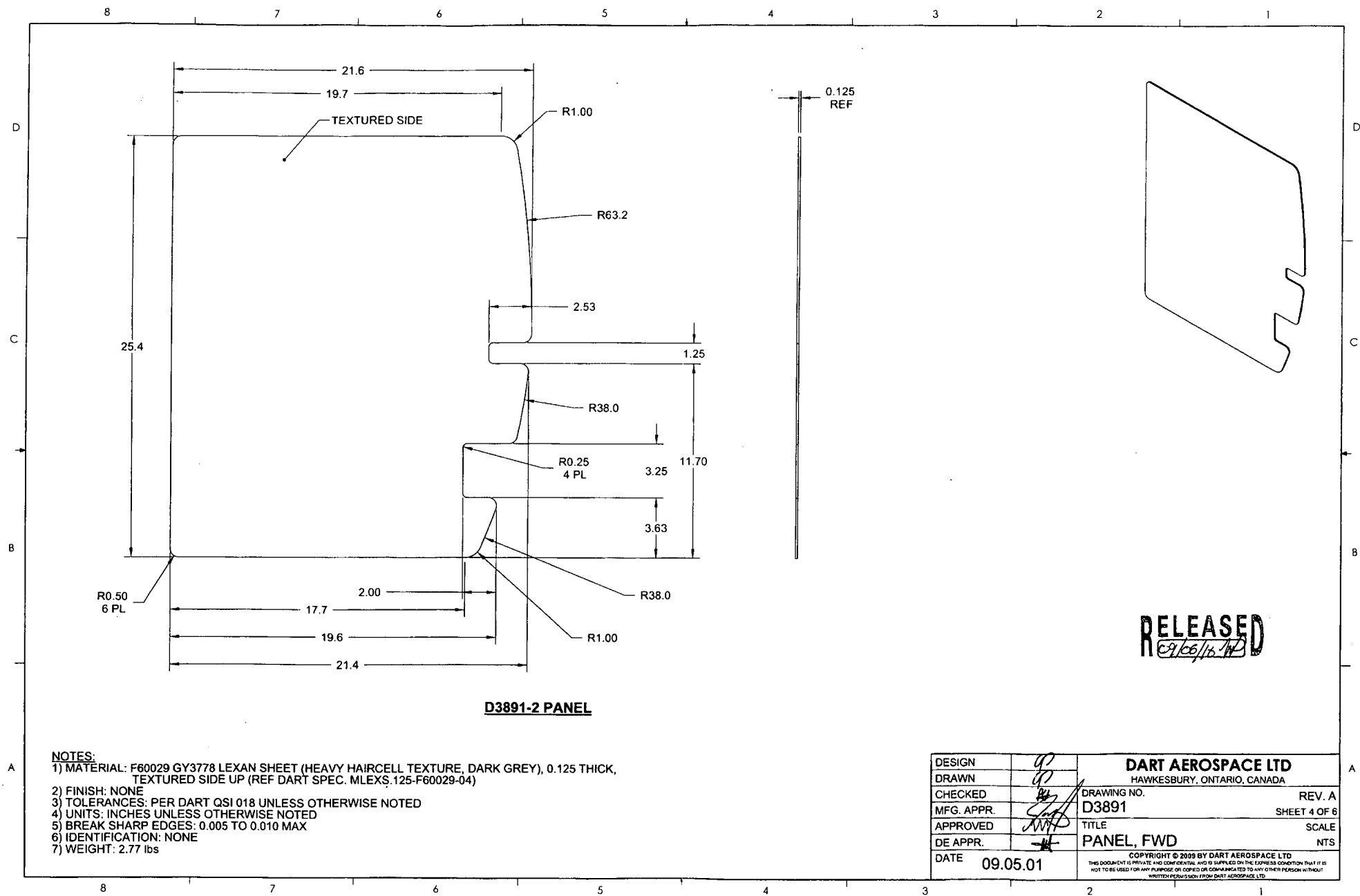
RELEASED
09/24/17

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DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	GP	D3891	SHEET 2 OF 6
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	PANEL, FWD	NTS
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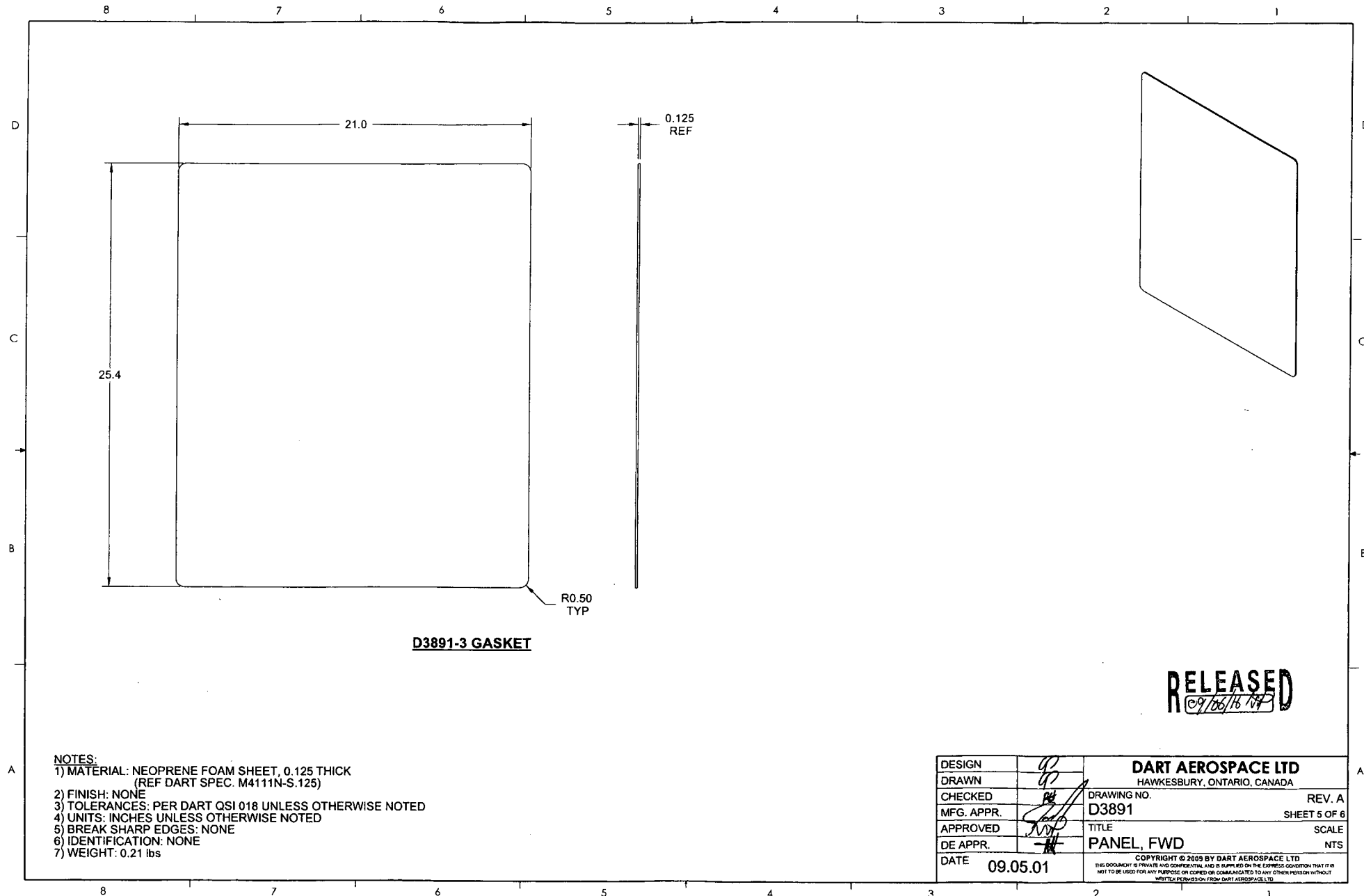
RELEASED
07/06/16

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DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DB	DRAWING NO.	REV. A
MFG. APPR.	GP	D3891	SHEET 3 OF 6
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	PANEL, FWD	NTS
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09/05/01

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. A
MFG. APPR.	90	D3891	SHEET 4 OF 6
APPROVED	90	TITLE	SCALE
DE APPR.	90	PANEL, FWD	NTS
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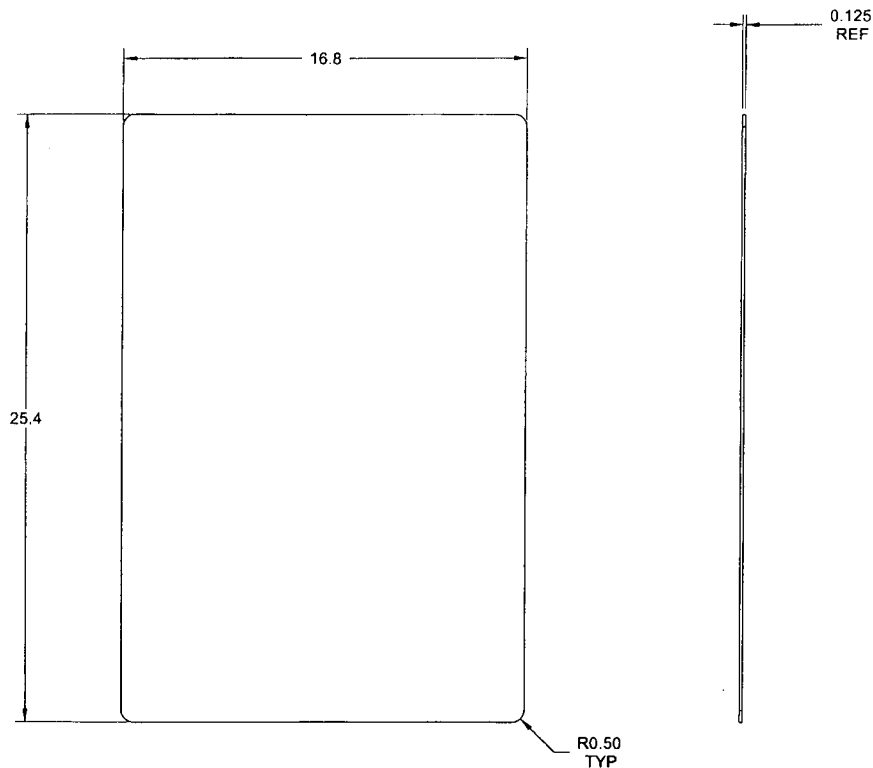
D3891-3 GASKET

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.21 lbs

RELEASED
09/08/16

DESIGN		DART AEROSPACE LTD	
DRAWN	93	HAWKESBURY, ONTARIO, CANADA	
CHECKED	94	DRAWING NO.	REV. A
MFG. APPR.		D3891	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		PANEL, FWD	NTS
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D3891-4 GASKET

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs

RELEASED
09/05/16

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	92	D3891	SHEET 6 OF 6
APPROVED	92	TITLE	SCALE
DE APPR.	92	PANEL, FWD	NTS
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